

5104007



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

DAS
13
9-89

D2622-120C
Job Sheet 179413



JUN 22 2018

Part No: D2622-120C

Job Qty: 240 ea

Part Name: Step Extrusion



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/19/18

Job Tracking No:

Due Date: 7/16/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV C1

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	240 pcs		7/16/18	0.00	0.00	Purchasing		AT AUG 21 2018
110	Packaging	240 pcs		7/16/18	0.00	0.00	Packaging2		AT AUG 21 2018
120	QC	240 pcs		7/16/18	0.00	0.00	QC18		AT AUG 21 2018
130	Packaging	240 pcs		7/16/18	0.00	0.00	Packaging3-1		SKL AUG 21 2018
140	QC21-SA	240 Ea		7/16/18	0.00	0.00	QC21		21 AUG 21 2018

Part Op 100 - Issue P/O: 40296 a) Extrude as per Dwg D2622 Rev. C f) Order at 120" longg) Bon L Canada Inc.

Descriptions: 110 - Ensure material certification is attached

120 - Check Pull test per Dwg D2622 for compliance page attached Check hardness with Webster tester

130 - LOCATION : HALL

DAS
13
9-89

JUN 22 2018

X 241

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120CP	Extrusion	240 pcs (1 ea)	100-Purchasing	5104003

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D2622-120CP	240	0	0

Part Specifications

Specifications could not be found.

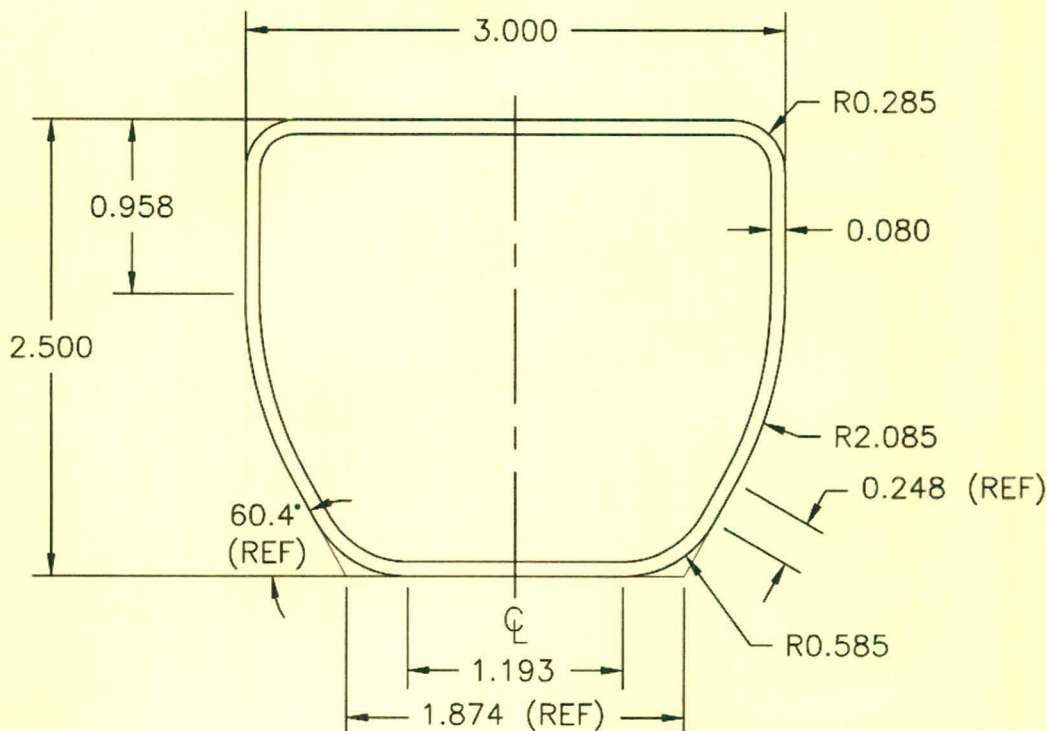
Plex 6/19/18 7:53 AM dart.lavoie.chantal

Aug 3 1908
Aug 4 1908
Aug 5 1908



DESIGN KE	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2622	REV. C SHEET 1 OF 1
DATE 02.09.11		TITLE STEP EXTRUSION	SCALE 1:1
A	96.11.29	NEW ISSUE	
B	97.12.12	CHANGE MATERIAL, ADD TOL. QSI	
C	02.09.11	0.080 WAS 0.085; ADD PART & DIE No.	
CI	GP 02.10.04	ADD 'REV. A' TO DIE NUMBER.	

RELEASED
02.09.11 #



D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 REV. A
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040296**

Supplier: SIG001-VC
Signature Aluminum Canada Inc.
C/O T10322C
PO Box 4488, STN A
TORONTO
ON
M5W 4H1 Canada
Phone: 905-427-6550
Fax: 905-427-2246

PO No: PO040296
PO Date: 6/22/18
Due Date: 8/13/18

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

E-MAILED

JUN 22 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments: QUOTE NO. 06202018-009

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	179423	D2423P		Lug Extrusion : AS PER DWG D2423 REV. B (EXTRUSION CUT AT 8 FT LONG) die # DAA-5-2 EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE OUTSIDE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES,NICKS,OR DENTS	Firmed	8/13/18	288 ft	0 ft 328 ft	288 ft	\$9.9248263/ft	\$2,858.35
2	179413	D2622-120CP		Extrusion : EXTRUDE AS PER DWG D2622-120 REV. C DIE # DAA- 897123 LENGHT 120" EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF TUBE MATERIAL MUST BE SMOOTH AND FREE FROM DEFECT SCRATCHES,NICKS,DENTS	Firmed	8/13/18	241 pcs	0 pcs 251	241 pcs	\$24.542323/pcs	\$5,914.70

Grand Total: \$8,773.05

Order Notes

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS



Plex 6/22/18 8:24 AM dart.lavoie.chantal

Carrier: MC GILLION

Shippers No: 038877

TRL 222407

From: SIGNATURE ALUMINUM CANADA

on 08/20/18

1850 CLEMENTS ROAD

PICKERING ON L1W 3R8



ISSUED AT SHIPPER'S REQUEST

ÉMIS À LA DEMANDE DE L'EXPÉDITEUR

Received, subject to the classifications and tariffs in effect on the date of issue of this Original Bill of Lading, or, received, subject to the Rules for the Carriage of Express and Non-Carload Freight Traffic and tariffs in effect on the date of issue of this Original Shipping Contract (Bill of Lading), goods described below, in apparent good order, except as noted (contents and conditions of contents of packages unknown), marked, consigned and destined as indicated below, which said Company agrees to carry to its usual place of delivery at said destination, if on its road, otherwise to deliver to another carrier on the route to said destination. It is mutually agreed, as to each carrier of all or any of said goods over all or any portion of said route to destination, and as to each party at any time interested in all or any of said goods, that every service to be performed hereunder shall be subject to all the terms and conditions (which are hereby incorporated by reference and have the same force and effect as if the same were severally, fully and specifically set forth herein).

1. Railway Traffic Liability Regulations (SOR/91-488 August 14, 1991) passage of the National Transportation Act, 1987.
2. of the bill of lading of the water carrier as provided in its tariffs of rules and Regulations when said goods are carried by a water carrier, or
3. of the bill of lading set forth in or prescribed by the relevant tariffs, classification, statutes and regulations pertaining to motor carrier's services when said goods are carried throughout by a motor carrier; or
4. of the bill of lading in Schedule 2 by D.C. 47-88 of January 13, 1988 when said goods originating in Quebec are to be carried by a motor carrier.
5. or approved by the Board of Transport Commissioners for Canada by General Order No. T-43, set forth in the Rules for the Carriage of Express and Non-Carload Freight Traffic and also available at all express and railway agency stations and express and freight offices upon request, when said goods are carried by a rail carrier, and which are agreed to by the shipper and accepted for himself and his assigns.

Reçu, sous réserve des classifications et tarifs en vigueur à la date de livraison de ce connaissement original, ou sous réserve des règlements régissant le transport des messageries et marchandises de détail et des tarifs en vigueur à la date de livraison de ce contrat de transport (connaissement), les marchandises désignées ci-dessous, apparemment en bon état, sauf les remarques contenues aux présentes (le contenu et l'état du contenu des colis étant inconnus), marquées et consignées tel que ci-après indique, et que la Compagnie s'engage à transporter à destination à son lieu habituel de livraison, pourvu que telle destination soit sur son parcours, sinon à les livrer à un autre voiturier faisant route vers cette destination. Il est de plus convenu que tout voiturier transportant tout ou partie desdites marchandises sur tout ou partie du parcours, que toute personne intéressée en aucun temps à tout ou partie desdites marchandises et que tous services prévus aux présentes seront assujettis à toutes les conditions (lesquelles, par renvoi, sont intégrées aux présentes et ont la même force et le même effet que si elles étaient ici énoncées séparément, et intégralement et expressément).

1. Le Règlement sur la responsabilité à l'égard du transport ferroviaire de marchandises (DORS/91 488, 14 août 1991) adoptée en vertu de la loi de 1987 sur les transports nationaux.
2. du connaissement du transporteur maritime, conformément aux dispositions et règlements énoncés dans les tarifs s'appliquant au transport par eau; ou
3. du connaissement prescrit par les tarifs, classifications, statuts et règlements se rapportant aux services de camionnage si lesdites marchandises sont transportées par camion; ou
4. du connaissement selon l'annexe 2 du Décret 47-88 du 13 janvier 1988, si les marchandises sont expédiées de la province de Québec par camion.
5. approuvées par l'ordonnance générale No. T-43 de la Commission Canadienne des Transports pour le Canada régissant le transport des messageries et marchandises de détail et dont le texte peut être obtenu sur demande à toutes les gares de voyageurs et de messageries, ainsi qu'à tous les dépôts de marchandises si lesdites marchandises sont transportées par un voiturier du rail, conditions auxquelles l'expéditeur consent et qu'il accepte pour lui-même et ses ayants droit.

Consigned To: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

S/O: 132699

Freight: Prepaid

No	Description Of Articles	LTl	Haz	Net	Tare	Gross
Pkgs		Cls	Mat			
6	Aluminum Lineal Shapes; Item 13515-A	60		2,317 lbs 1,051 kgs	106 lbs 48 kgs	2,423 lbs 1,099 kgs

44x2
42x3
35

6	TOTAL	2,317 lbs 1,051 kgs	106 lbs 48 kgs	2,423 lbs 1,099 kgs
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Shipper, Per T1TONKS
SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

CANADA

CARRIER / AGENT				CONSIGNEE / CONSIGNATAIRE			
DATE	D/J	M/M	Y/A	DATE	D/J	M/M	Y/A
PER / PAR				PER / PAR			

Visit us at www.signaturealum.com

FORM NO. B1018 REV C

**SIGNATURE ALUMINUM CANADA**1850 CLEMENTS RD
PICKERING, ON L1W 3R8**CERTIFICATE OF COMPLIANCE**

Cert Date	Cert No.	Sales Order	Page
08/12/2018	5491642	132699	1
Cust PO	B/L No	Lot	Date
PO040296	038877	903813	08/20/18

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
002	DAA-897123-2	10FT MILL-6061 T6	D2622-120CP
Gross Weight	2,423 LBS		
Net Qty	2,317 LBS 259 PCS 6 PKGS		
Specification	Die Desc		
AMS-QQ-A-200/8 & ASTM B221-08			

Mechanical Tests:

<u>Tensile</u>	<u>Yield</u>			
<u>MPA / KSI</u>	<u>MPA / KSI</u>	<u>% Elongation</u>	<u>Conductivity</u>	<u>HRE</u>
286.2 / 41.5	253.8 / 36.8	11.0	N/A	93

Chemical Analysis:

<u>Si</u>	<u>Fe</u>	<u>Cu</u>	<u>Mn</u>	<u>Mg</u>	<u>Cr</u>	<u>Zn</u>	<u>Ti</u>	<u>V</u>	<u>Zr</u>
0.59	0.23	0.21	0.08	0.88	0.08	0.05	0.01	0.01	0.00

*This Material is Made in Canada**This Material is RoHS Compliant*

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Gooder
Quality Manager
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

Rev A

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D2622-12d
 DATE: 18/08/21

PO / BATCH NO.: P0040296/S104007

MATERIAL CERT REC'D: Yes
 QUANTITY RECEIVED: 259
 QUANTITY INSPECTED: 259
 QUANTITY REJECTED: 0

THICKNESS ORDERED:
 THICKNESS RECEIVED:
 SHEET SIZE ORDERED:
 SHEET SIZE RECEIVED:

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	(N)	
CORRECT FINISH	(Y)	N	
CORROSION	Y	(N)	
CORRECT GRAIN DIRECTION	(Y)	N	
CORRECT MATERIAL PER M-DRAWING	(Y)	N	ASTM-A240-2008
CORRECT THICKNESS	(Y)	N	
PHOTO REQUIRED	Y	(N)	
CORRECT REF # TO LINK CERT	(Y)	N	P0040296
CORRECT MATERIAL IDENTIFICATION	(Y)	N	
CORRECT M# ON THE MATERIAL	(Y)	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	(N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	(N)	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL SIZE OF TEST SAMPLE HARDNESS / DUROMETER READING	HRC	HRB	DUR A	DUR D	WEBSTER

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>AT</u>	SIGNED OFF BY: <u> </u>
DATE: <u>18/08/21</u>	DATE: <u> </u>

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

